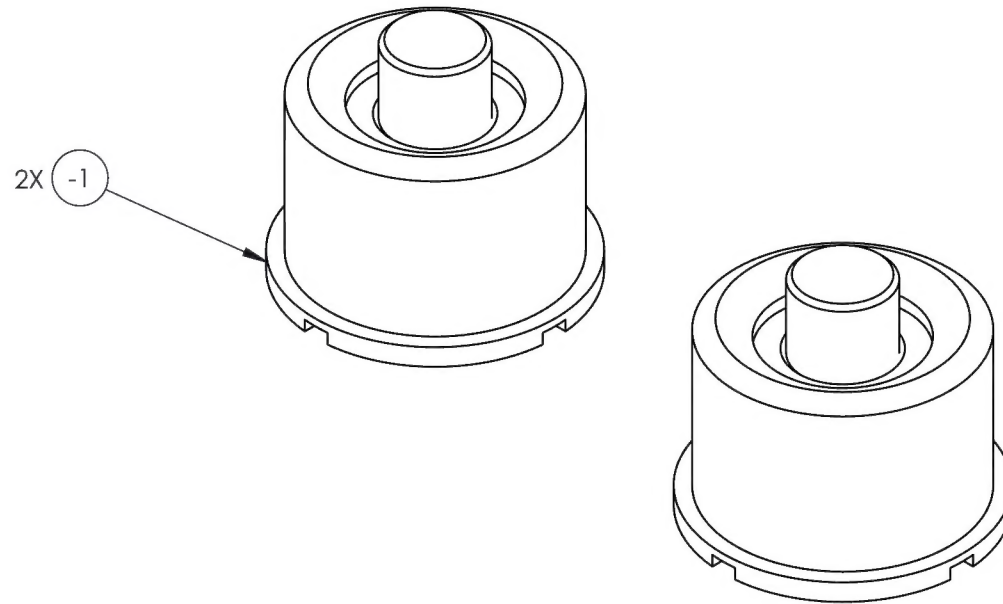


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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
1		RELEASED FOR PRODUCTION.	5/24/2016	DPD	JAG



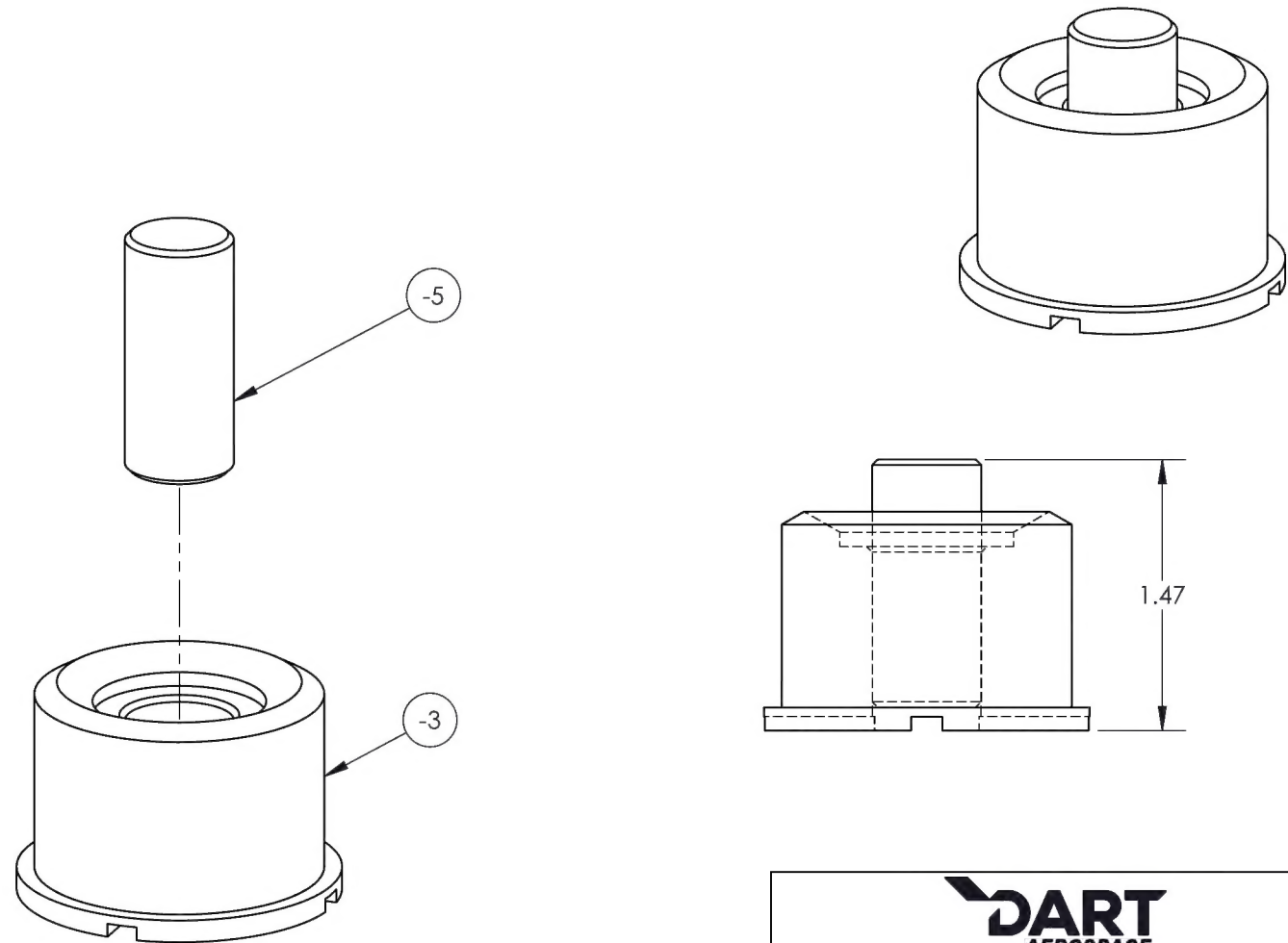
NOTE:
REF. EUROCOPTER T/N: 105-42121W6.

DART AEROSPACE	
TITLE STAKING TOOL	
DWG NO. RBE105-42121W6	REV 1
MAT'L HEAT TREAT FINISH SPEC	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 FRACTIONS ± 1/8 .XX ± .01 ANGLES ± .5° .X ± .1 SURFACES = 125° ✓	
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING 3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009	
DRAWN BY: DUERFELDT CHECKED: CLOUGH OPPTS APPR: ANDERSON QA APPR: LINDSAY APPROVED: GILBERT	
USED ON MODEL EC145	
SCALE 1:1	DATE 1/20/2016
SHEET 1 OF 4	

ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.
	X		-1	2	STAKING TOOL ASSEMBLY			2
	1		-3		STAKING INSERT	4140/4142		3
	1		-5		GUIDE PIN	4140/4142		4
	ASSY -1							

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REVISIONS				
REV	ECR	DESCRIPTION	DATE	INITIAL
				APPROVED

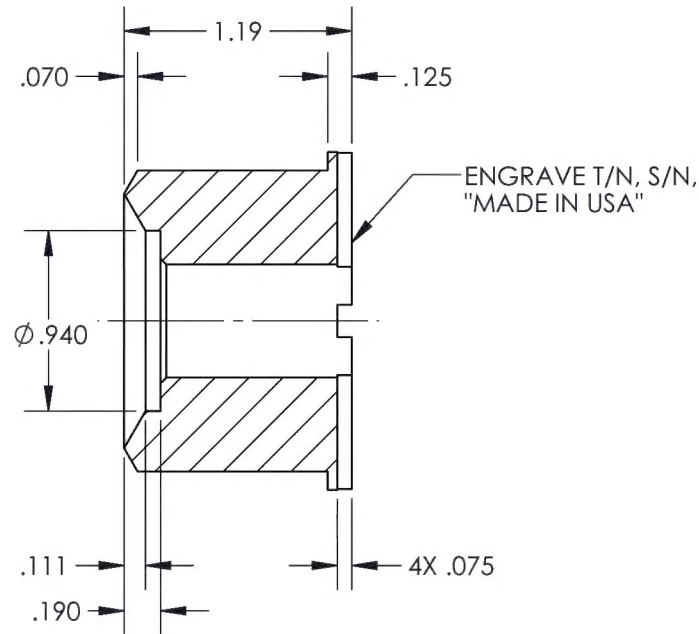
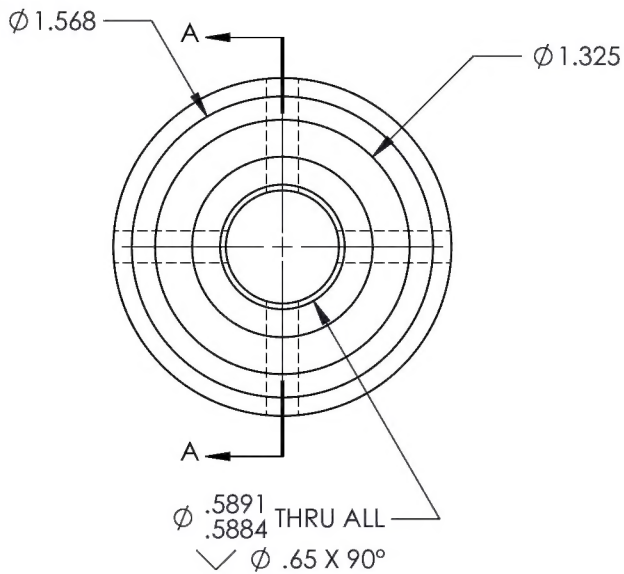


-1
STAKING TOOL ASSEMBLY

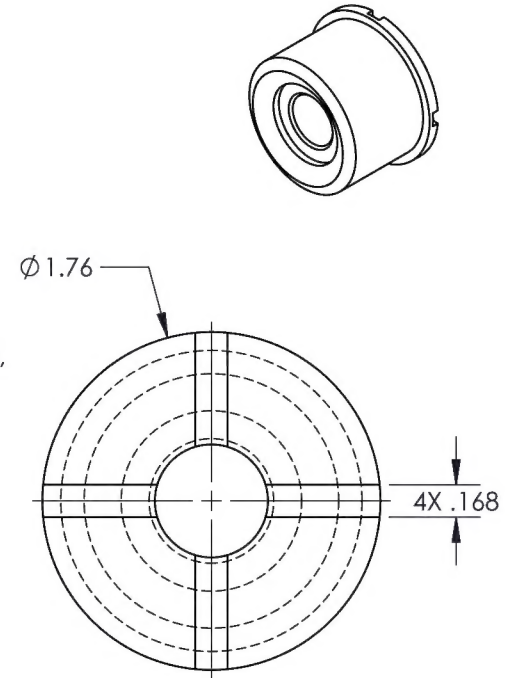
DART AEROSPACE	
TITLE STAKING TOOL	
DWG NO. RBE105-42121W6-1	REV 1
MAT'L ZINC PLATE	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
HEAT TREAT ZINC PLATE	.XXX ± .005 FRACTIONS ± 1/8
FINISH ZINC PLATE	.XX ± .01 ANGLES ± 5°
SPEC ASTM B633 TYPE I SC 2	.X ± .1 SURFACES = 125° ✓
DRAWN BY: DUERFELDT	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
CHECKED: CLOUGH	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
OPPS APPR: ANDERSON	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
QA APPR: LINDSAY	USED ON MODEL
APPROVED: GILBERT	EC145
SCALE 1:1	DATE 1/20/2016
SHEET 2 OF 4	

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REVISIONS				
REV	ECR	DESCRIPTION	DATE	INITIAL
				APPROVED



SECTION A-A

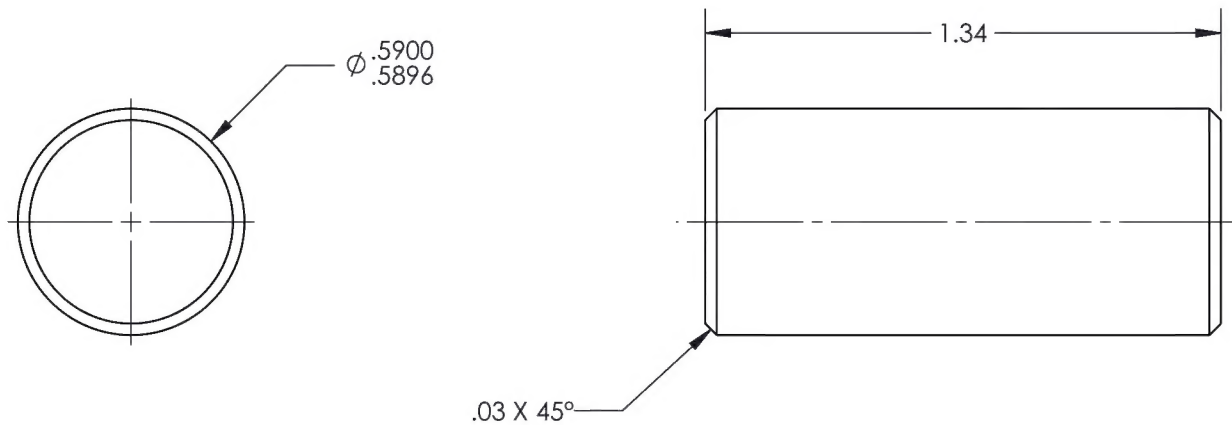
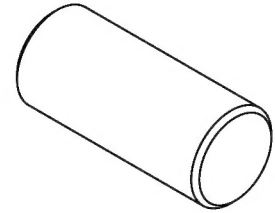


(-3)
STAKING INSERT

DART AEROSPACE	
TITLE STAKING TOOL	
DWG NO. RBE105-42121W6-3	REV 1
MAT'L 4140/4142 TREAT RC 50-55 FINISH SEE -1 SPEC	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX \pm .005 FRACTIONS \pm 1/8 .XX \pm .01 ANGLES \pm 5° .X \pm .1 SURFACES = 125°
DRAWN BY: DUERFELDT CHECKED: CLOUGH OPPS APPR: ANDERSON QA APPR: LINDSAY APPROVED: GILBERT	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING 3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
USED ON MODEL EC145	
SCALE 1:1	DATE 1/20/2016
SHEET 3 OF 4	

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REVISIONS							
REV	ECR	DESCRIPTION			DATE	INITIAL	APPROVED



(5)
GUIDE PIN

DART AEROSPACE	
TITLE STAKING TOOL	
DWG NO. RBE105-42121W6-5	REV 1
MAT'L 4140/4142	UNLESS OTHERWISE SPECIFIED
HEAT TREAT RC 50-55	DIMENSIONS ARE IN INCHES
FINISH SEE -1	.XXX ± .005 FRACTIONS ± 1/8
SPEC	.XX ± .01 ANGLES ± .5°
	.X ± .1 SURFACES = 125/✓
DRAWN BY: DUERFELDT	1. BREAK ALL SHARP EDGES
CHECKED: CLOUGH	.015 x 45° OR .015R
OPPS APPR: ANDERSON	2. DIMENSIONAL LIMITS APPLY
QA APPR: LINDSAY	AFTER PLATING
APPROVED: GILBERT	3. INTERPRET DIM AND TOL PER
	ASME Y14.5M-2009
SCALE 2:1	USED ON MODEL
DATE 1/20/2016	EC145
	SHEET 4 OF 4